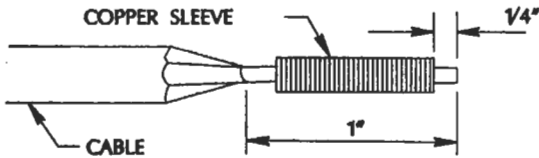
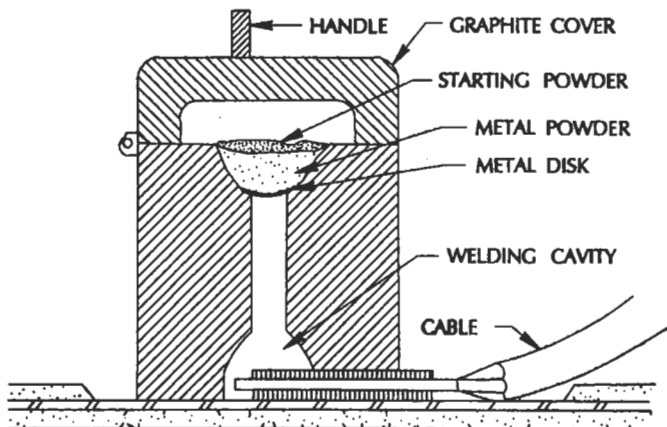


### STEP 1



### STEP 2



### STEP 3



### STEP 4

## WELDING INSTRUCTIONS

### STEP 1

REMOVE EXISTING COATING AND CLEAN PIPE TO WHITE METAL WITH FILE GRINDER OR METAL RASP.

### STEP 2

REMOVE INSULATION, SLIP ON COPPER SLEEVE AND CRIMP.

### STEP 3

INSTALL CABLE AS SHOWN. PLACE POWDER IN MOLD AND CLOSE COVER. IGNITE WITH FLINT GUN AND HOLD WELD MOLD IN POSITION FOR 10 SECONDS.

### STEP 4

REMOVE SLAG AND TEST WELD WITH SHARP HAMMER BLOW. REPLACE COATING ON MAIN & COAT WELD AND BARE COPPER WITH 1/4" MIN. COATING OF SAME MATERIAL OR WITH 10 MIL PVC TAPE, HALF- LAPPED.

## WELDING SPECIFICATIONS

### CADWELD

CONDUCTOR- #10 OR #12 SOLID	STEEL OR DUCTILE IRON	CAST IRON
WELDER	CAM-108	CAHBA-1G
SLEEVE	CA-26180	CA-26180
CARTRIDGE	CA15-F33	CA25-XF19
CONDUCTOR- #8 STRANDED	STEEL OR DUCTILE IRON	CAST IRON
WELDER	CAM-109S	CAHBA-1L
SLEEVE	CAS-421	CAS-421
CARTRIDGE	CA15-F33	CA45-X519

APPROVED BY

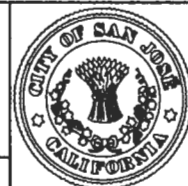
*Wash*

DATE

4-2-92

## CABLE TO PIPE EXOTHERMIC WELD

DEPARTMENT OF PUBLIC WORKS



DRAWING  
NO.

W-13